October-08-13 11:	09:27 AM			*108		<u> </u>					*
Item ID: D4 Révision ID:	1093-1			Accept	*N900	ัก 4 ก	100)*. s	etup Start	* N	S1*
	acket .	·							Stop	*N	S2*
Start Date: 10 Required Date: 10 Reference:	/08/13 /08/13	Start Qty: 10.00 Req'd Qty: 10.00	*1(*1(Cust Item I Customer:	D: `		•	•	•	
Approvals: P	rocess Plai	1: MLJ	Date: \3-\0-	Tooling:	. Da	ite:	-	R	un' , Start	I V	R1*
				SPC (Y/N):	. Da	ite:			Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description	<u></u>	Set Up/ Run Hours	· Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D4093	D						*,				·
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110 Waterjet		Memo		.0.00	•	•		10		ing order ones.	Ac 13.10.1
FLOW CNC Waterjet		CUT AS DW DWG REV:_ PROG REV:			,			,			,,,
		HOLES \	WILL BE MADE ON	I MILLING	•	,				•	• •
		****DEBUR	R****		· , •		ž.	-	٠.		•
120		QC2- Inspect parts off ma	achine FAI/FAIB	0.00							3
120		Memo		0.00				<u>.</u>			se .

											DQA:	D	ate:	
NCR: Y	es / N)			WORK ORDER NON-C	100	VFORM	MANCE / UP	DATE		-			
					•					_	QA Closed:	D	ate:	
Work Orde	or.				DISPOSITION				AGAINST I	ЭE	PARTMENT,	PROCESS		
WOIK OIGE					Rework	1		Skid-tube	Crosstube	—]	Water Je	t┌┐	Engineering
Part N	۱o.				Scrap			Machining	Small Fab	\dashv	Pro	d. Eng. Coor		Quality
	-				Use-as-is		Therm	noforming	Finishing		Rec/Sto	e/Packagin	3	Other
NCR N	No				Work Order Update			Large Fab	Composite]	Supplie	r	
					<u> </u>						7			,
Root			1	1	ption of work order update		Initial		tion	,	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription		Date	Verificati	on	QC Inspector
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Equip/Tooling	Ш					1						1		
Operator														
Material		[1											
Setup	A SERT	? [.	1											
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Process														
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Training			1											
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Landi	ng Gear				General		_		_		_			_
	Bendi	ng			Bend		Grain				Ovalized			Pressure/Forced
ļ	Centre	Not Conce	entric to	o/s	BOM/Route		Hardwa	ire			Over/Under	tolerance	L	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	ion Incomplete			Part Incorre	ct		Weld
	Crush	ed/Crimped	t		Burrs		Instruct	tions Incomplete/	'Unclear		Part Lost/M	ssing		Wrong Stock Pulled
l	Cuffs				Contamination	Г	Mainte	enance			Part Moved			_

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Heat Treat

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde October-08-13			-	*108	3191*				Page	2
Item ID: Revision ID: Item Name:	D4093-1 Bracket			Accept	*N900	0040100) * :	Setup Start Stop	*NS1* *NS2*	
Start Date: Required Date: Reference:	10/08/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item Customer:				14. 17	
Approvals:		in:		Tooling: SPC (Y/N):		Date:	1	Run Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II)	Operation Description	e agreement e agreement e en e	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp	
130 Mill Conv Conventional Millin	g Machine	Memo DRILL AND) C'SINK AS PER DWG	0.00		(P70)	_10_	y		124
132		QC2- Inspect parts off ma	achine FAI/FAIB	0.00					J.	JP.
137 QC Quality Control	·	Memo		0.00				_/	<i>[13[1</i>	10/2 g
135 *135*		QC8- Inspect parts - seco	ond check	0.00	(AS)	3/10/24	_(0	φ	()	了 (C
QC		Memo		0.00	<i>3</i> -8 ⁻ 2	1,5121		1		

Quality Control

NCR: Y	'es /	No				WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: 3/1/1						13/11/11	
Work Orde	er:		168	191		DISPOSITION	1			AGAINST DE	PARTMENT	_	
	10 10					Rework Scrap Use-as-is Work Order Update		1	Machining X S	Crosstube Small Fab Finishing omposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Action		Sign &		
Cause	Da	ite	Step	Qty	•	or Non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	13.1	6.27	130	4	Fran	5 0.009" OFF () "holu: the way setup concly,	1 1	1688 1024	THIS IS AN LOCE DEVIATION: 1.5 ed = G.3 LOTUAL ed=0	02"	frst 13/10/24	(PAS (PAS) 13/10/24	DAS 16 9-89
	<u> </u>					F.	AUL	T CATE	GORY				
Landi	ng Gear					General		•		_	•		-
-	Crac Crus Cuff Heat Insp	re Not ks hed/C s t Treat ection les in	Strip in	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/Uncle enance eled	ear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turr	ing Se	ouence			Finish		Out of	Seauence				·

Outside Dimensions

Wave/Twist in Tube

Folio

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QC7-Inspect Chemical Conversion Coat 0.00 *160*

0.00 Memo Quality Control

Identify as per dwg & Stock Location: 0.00 170

170 0.00 Packaging Memo Packaging

Reject Insp. Number Stamp

Page 3

7613-1074

											DQA:	Da	ite:	
NCR:	⁄es	/ No				WORK ORDER NON-	100	VFORM	MANCE / UPDATE					-
											QA Closed:	Da	te:	
Work Orde	ar.					DISPOSITION			AGA	INST DE	PARTMENT,	/PROCESS		
WOIK Old	-					Rework	7		Skid-tube Cross	tubo		Water Jet		Engineering
Part N	J۸					Scrap	1		—	l Fab	Pro	d. Eng. Coor.	\vdash	Quality
1 0.00	•••					Use-as-is	1		· -	shing	i	e/Packaging	_	Other
NCR I	Vo.					Work Order Update	┨	11.0111	Large Fab Comp	· -	1100	Supplier	_	
	•												ш	
Root					Descri	ption of work order update		nitial	Action	_	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ct	ief Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data														
Equip/Tooling					i I									
Operator														
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Other														
Process			1											
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Landi	ng (Gear				General		=						
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks			L	Broken/Damaged	L	Inspecti	on Incomplete		Part Incorred	ct		Weld
]		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord October-08-13							Page 4						
Item ID: Revision ID: Item Name:	D4093-1 Bracket			Accept	*N900	040	100)* s	etup	Start Stop	*N *N	S1* S2*	
Start Date: Required Date Reference:	10/08/13 e: 10/08/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item II Customer:	D:						-	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ite:		F	Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center 180 *1 8 \cap * QC Quality Control		Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Nûmber U.3. M	Insp. Stamp	29

					•						DQA:	Date:	·
NCR: Y	/es	/ No				WORK ORDER NON-O	100	NFORI	MANCE / UP	DATE			
											QA Closed	. Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	- No		<u> </u>			Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet od. Eng. Coor.	Engineering Quality Other
NCR N	NO					Work Order Update	j		Large Fab	Composite	1	Supplier] []
Root Cause		Date	Step	Qty		ption of work order update	1	Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data	П	Dute	Jiep	α.,	`	or tron comormance	<u> </u>	iici Liig	2030	· · · · · · · · · · · · · · · · · · ·			- Gospeeco.
Equip/Tooling							ĺ						
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Process	Щ		1										
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ļ							AUI	LT CATE	GORY				
Landi					_	General	_	٦.			7	Γ	-
	\vdash	Bending			<u> </u>	Bend	_	Grain			Ovalized	<u> </u> _	Pressure/Forced
	1	Centre N	ot Conce	ntric to	o/s l	BOM/Route	1	Hardwa	are		Over/Unde	r tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Loc Oty

32.01

30.78

1.23

Loc Code

13/10/16 m606176B0,750×8.000/B122321 121380

120866

Location MAT005

6061T6 BAR .750 X 6.00

6.11

Page 1

Status

									DQA.	Date	•
NCR: Y	es / No			•	WORK ORDER NON-C	CONFOR	MANCE / UP	DATE	QA Closed:	Date	
					DISPOSITION	- 		AGAINST DE		<u></u>	•
Work Orde	er:				DISPOSITION	_		AGAINST DE	- PANTIVILIVI	/ PROCE33	_
Part N	lo				Rework Scrap Use-as-is	Ther	Skid-tube Machining moforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update]	Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &	1	
Cause	Date	Step	Qty	(or Non-conformance	Chief En	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling					÷						
Operator				÷							
Material											
Setup											
Other [ŀ								
Process							<i>*</i>		,		
Supplier			'							1	
Training			•								
Unapproved		<u> </u>		L		<u> </u>				<u> </u>	
			· · · · · · · · · · · · · · · · · · ·			AULT CAT	EGORY				
Landir	ng Gear			_	General				1		
	Bending			_	Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw		_	Over/Under	-	Temperature/Cure
	Cracks			_	Broken/Damaged	-	tion Incomplete	· ,	Part Incorre		Weld
İ	Crushed/	Crimped		<u> </u>	Burrs	\vdash	ctions Incomplete/	/Unclear	Part Lost/M	-	Wrong Stock Pulled
	Cuffs			ļ	Contamination	\vdash	tenance		Part Moved		
	Heat Trea				Countersink	Mislat			Positioned \		-
	Inspectio		Tube	<u> </u>	Cut Too Short	Misre			Power Loss/	'Surge	Other
	Ripples in	n Bend		1	Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

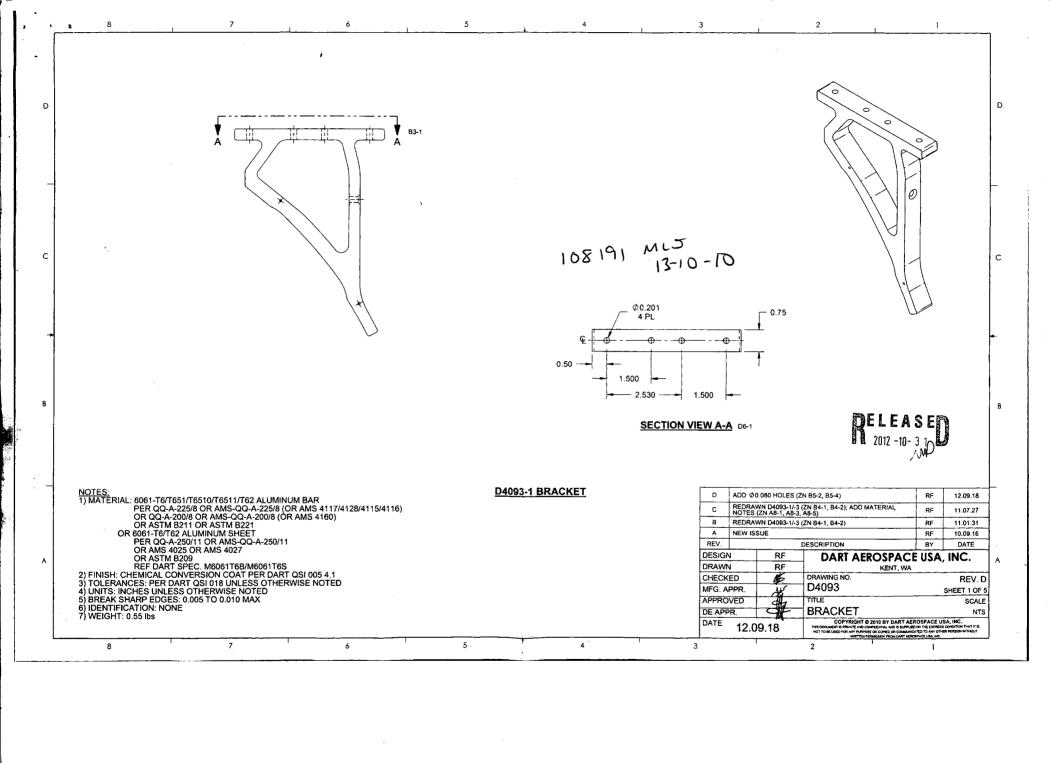
DART AEROSPACE LTD	Work Order:	108191
Description: Bracket	Part Number:	D4093-1
Inspection Dwg: D4093 Rev: D		Page 1 of 1

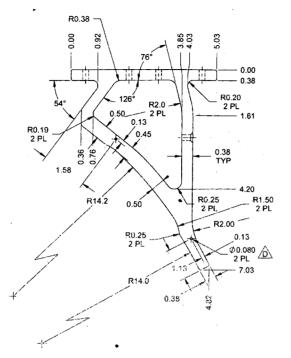
FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of inspection	Comments
Dimension		Dimension				
0.92	+/-0.030	.92"			V	MARO TO THE COLUMN TO THE COLU
3.85	+/-0.030	3.85" 4.03"	-		V	
4.03	+/-0.030	4.03"			V	
5.03	+/-0.030	5.01"	-		V	
0.36	+/-0.03/0	.36"			V	
0.76	+/-0.030	176"			V	
4.82	+/-0.030	4.82 88"			V	
0.38	+/-0.030	. 38"			V	
4.20	+/-0.030	d an"	_		V	
7.03	+/-0.030	7.02"	-		V	
0.750	+/-0.010	752"			٧	
Ø0.080	+0.005/-0.000			<u> </u>		
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						· .
			2AQA			

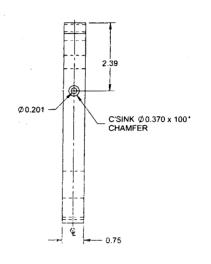
L		LOAS.		
Measured by:	1	Audited by: 740	Preliminary Approval:	
B 4		Date: 12 /09 /	Date:	
Duto.	1 1 2 1 10 110 1			

Rev	Date	Change	Revised by	Approved
	11.10.13	New Issue	KJ IN	
			KJ OX	NA .
B	13.05.08	Dimensions updated per Dwg Rev D		(13-1





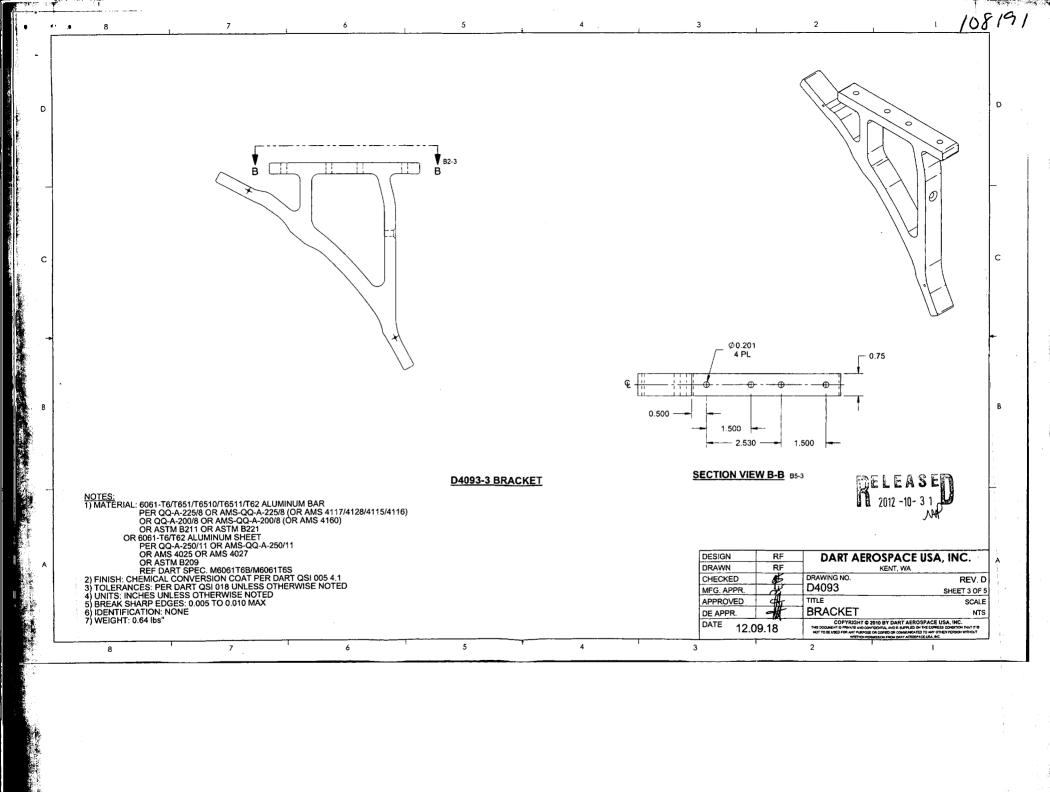
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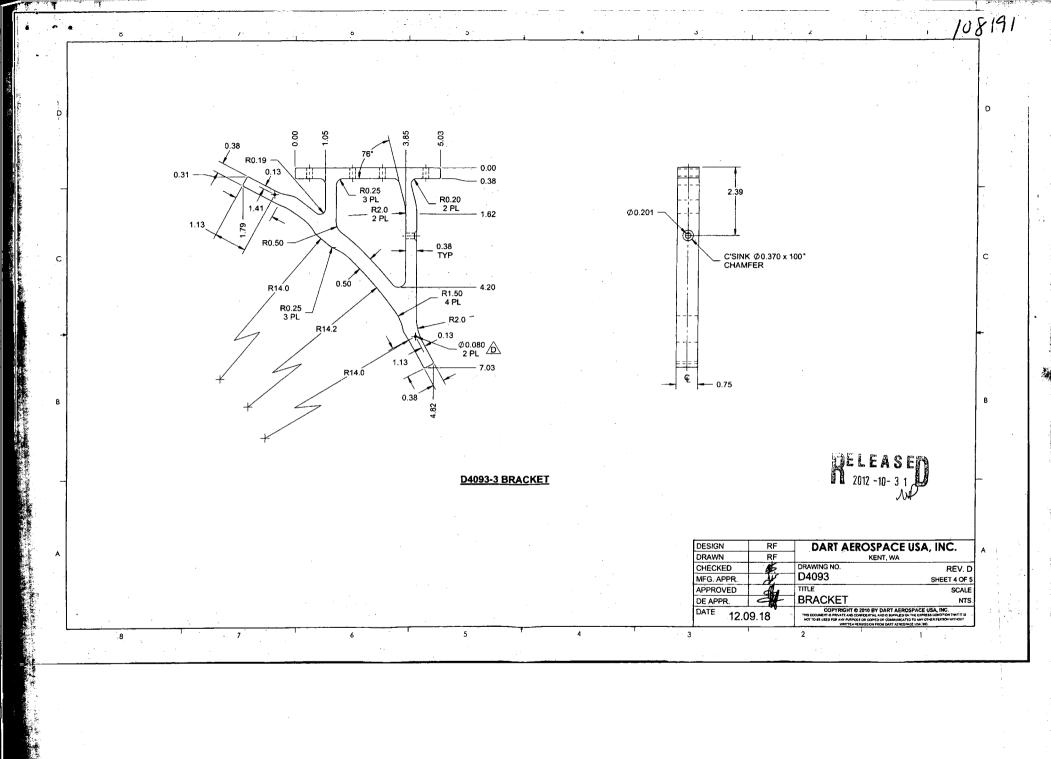


D4093-1 BRACKET

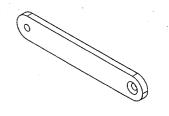
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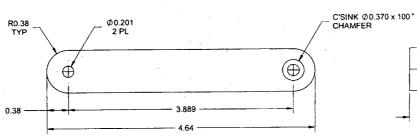
DESIGN	RF	DART AEROSPACE USA, INC		
DRAWN	RF	KENT, WA		
CHECKED	45	DRAWING NO.	REV. D	
MFG. APPR.	Al	D4093	SHEET 2 OF 5	
APPROVED	41	TITLE	SCALE	
DE APPR	4	BRACKET	NTS	
DATE 12.09.18 COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.		SUPPLIED ON THE EXPRESS CONDITION THAT IT IS		

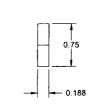












D4093-5 BRACKET

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-220/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR

DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF			
CHECKED	1	DRAWING NO.	REV. D	
MFG. APPR.	W	D4093	SHEET 5 OF 5	
APPROVED	d.	TITLE	SCALE	
DE APPR.		BRACKET	· NTS	
DATE 12.09.18		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS OSCUMENT IS PRIVATE AND CONFIDENTIAL DIES EXPENDED ON THE EXPENSE SIGNOTION THAT IT IS NOT TO BIS USED FOR YAM PURPOSE ON COMPLICATED TO JAMY CITIZER PERSON WITHOUT.		

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DART AEROSPACE LTD	Work Order:	108191
Description: Bracket	Part Number:	114093-1
Description.		
Inspection Dwg: // 4093 - Rev: //		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
00,201	+ 0,005	0,203	/		MSP-04	ven
0 500	: 0,010	0,496			111	///
1.500	+ 0,010	1.502			111	/ / \
2.530	± 0,010	2.578			111	, , ;
1500	- 0010	1,501			,,,	, , ,
) 39	+ 0,030	2.375			///	///
8 0,370 x100	.1 /	0 371 x/m				111
0 13	+ 0,030	0145	/		111	,,,
1 52	± 0,030	1500			///	111
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			· OAS		
Measured by:	MISP	Audited by:	40	Preliminary Approval:	
Date:	13/10/24	Date:	13/10/24	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.06.15